

5/22 (4)

DART AEROSPACE LTD	Work Order:	23407
Description: Step Leg	Part Number:	D3077-1
RF 03.02.28 RF 03.02.28		D3170-1
Dwg: D3077 Rev. A1 A2 D3170 Rev. A	Qty:	20
RF 03.02.17		Page 1 of 1
		Stack of 10

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	XJ	05.05.20	20
2	MV	Cut blanks: 12.100" x 5.070" (+0.030/-0.000) Material: 5052-H32 (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch: M17695 Identify as D3077-1	J.L	05/05/31	20
3	MV	Cut blanks: 11.990" x 0.750" (-0.00/+0.010) Material: 5052-H32 (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch: M17695 Identify as D3170-1	J.L	05/05/31	20
4	MV	Machine per Folio FA284 and Dwg D3077	SD	05.06.01	20
5	QC2	Inspect parts as they come off the CNC machine	SD	05.06.01	20
6	MV	Deburr to take measurement	SD	05.06.01	20
7	QC8	Second inspection	J.M	05.06.01	20
8	MV	Machine per Folio FA282 and Dwg D3170	SD	05.06.01	20
9	QC2	Inspect parts as they come off the CNC machine	SD	05.06.01	20
10	MV	Deburr to take measurement	SD	05.06.01	20
11	QC8 & 5	Second inspection	J.M	05.06.01	20
12	GA	Deburr D3077-1 and D3170-1 stack	FF	05/06/12	20
13	FP	Acid etch and Alodine per QSI 005 4.1 D3077-1 and D3170-1	ML	05.06.02	20
14	QC5	Inspect work to Step 13	2	05.06.03	20
15	GA	Identify and Stock D3077-1 and D3170-1	2	05.06.03	20
16	AC	Cost / part 7.30	AP	05-06-03	20
17	DC	Close W/O 7.70 Inspect Level 21	SD	05.06.03	20

Rev	Date	Change	Revised By	Approved
A	02.10.11	New issue	KJ	
B	02.11.18	Incorporated D3170-1 IPP	KJ RF	

RELEASED
02-11-20 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

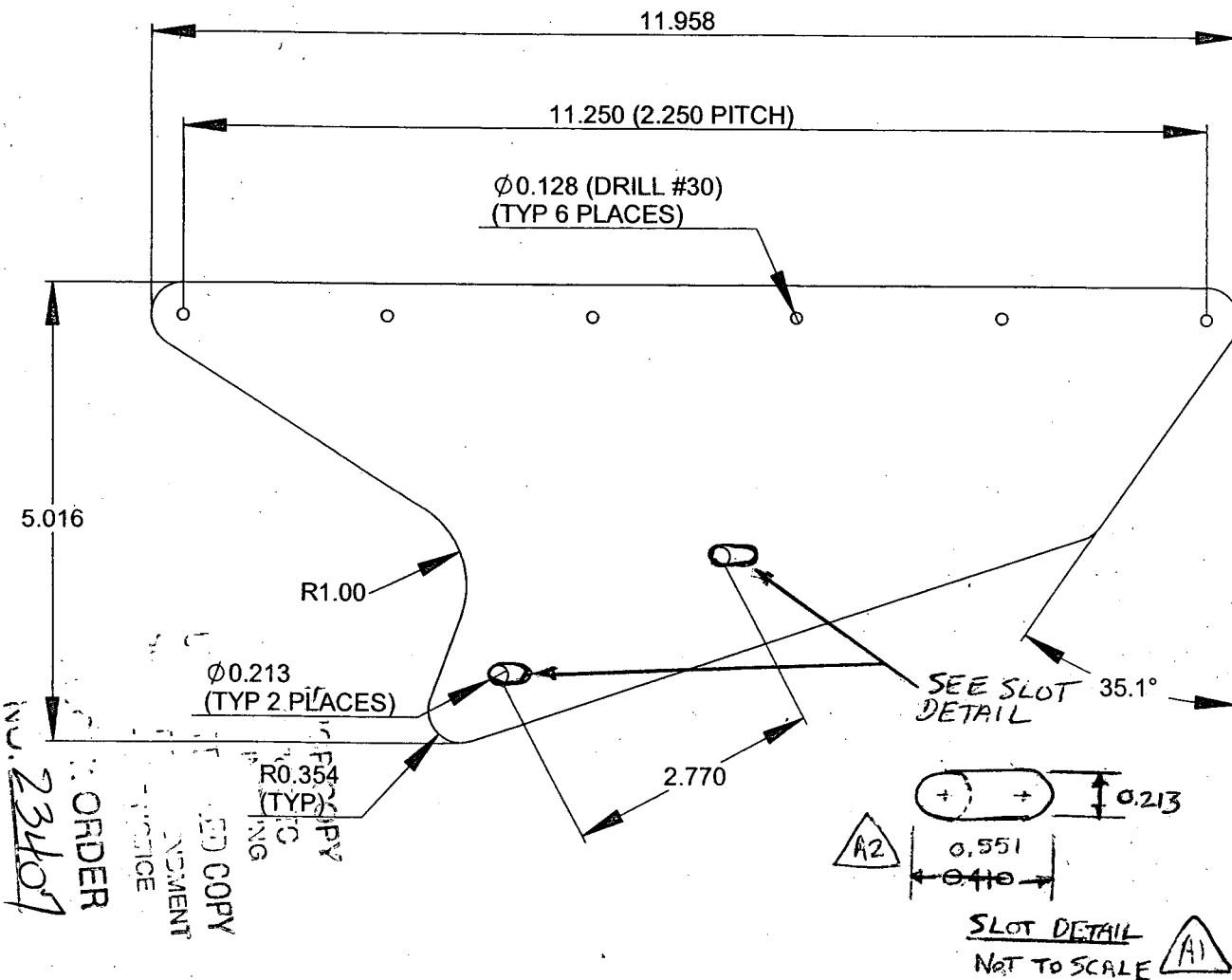
QA: N/C Closed: _____ Date: _____

RELEASED
JAN 05 03



RELEASED
02.04.2007

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
CP	CP	D3077
DATE	TITLE	REV. A
02.09.11	STEP LEG	SHEET 1 OF 1
A	02.09.11	NEW ISSUE
A1	03.02.13	ADD SLOTS
A2	03.02.27	0.551 WAS 0.410



D3077-1 STEP LEG

- 1) MACHINE PER DWG FILE "D3077-1.SLDPRT"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

COPYRIGHT ©2002 BY DART AEROSPACE LTD.

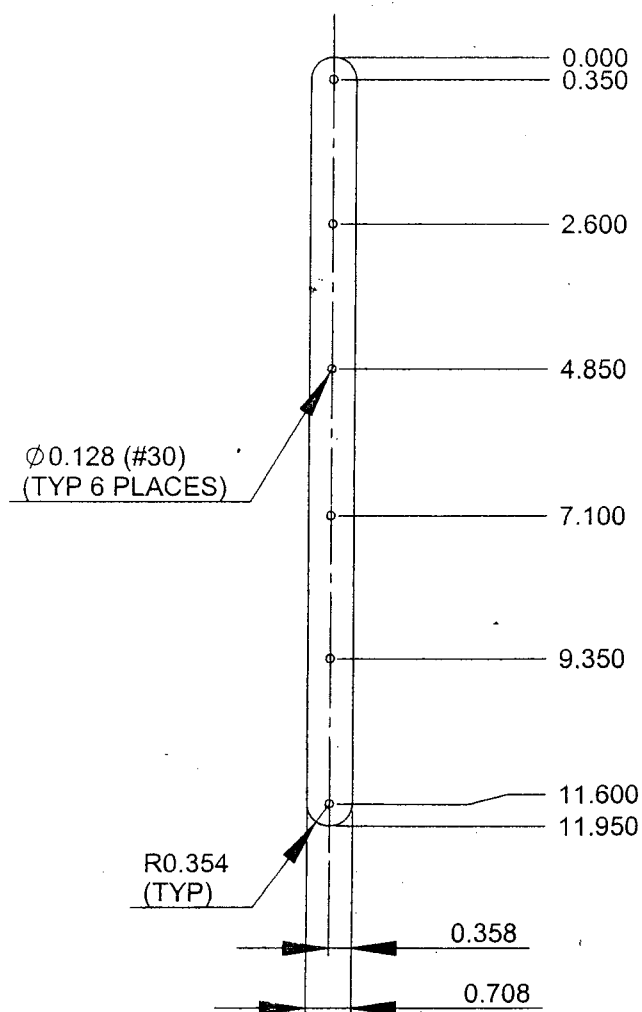
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

CONTROLLED COPY



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3170	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE SPACER	SCALE 1:3
A	02.09.11	NEW ISSUE	

RELEASED
02.09.20 [Signature]



REFERENCE ONLY

D3170-1 SPACER

- 1) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

COPYRIGHT ©2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 20, 2005
09:59 am

Work Order No : 0023407
Project Name : D3077-1
Project For : WK522
Work Order Type : Main
Main WO Number :
House Part Number : D3077-1
Description : Step Leg
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 05-20-05
Est Finish Date : 05-31-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00